

Work Order ID 68117

Wednesday, April 06, 2011 3:00:03 PM

9 April 15th Page 1

Item ID: D4271-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Beam Assembly

Start Date: 4/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: 11-04-06

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4271

B

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Pick and Assemble as per dwg

9/5/04/14 ①

110

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

SP 11/6/14

120

0.00



Packaging

Identify as per dwg & Stock Location: *196*

Memo

0.00

Packaging

11/4/15 *SP*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

n/4/18
MF
11-04-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Picklist Print

Wednesday, April 06, 2011 3:00:00 PM

Page 1

Work Order ID: 68117

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 4/7/2011





Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC
11.01.26 RevB dwg EC verified by:DD

IPP RevB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C13A  BOLT		Purchased	No				Each	17.0000		2		4/5/14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST357		17							
					116914	17							
MS21043-4  Nut		Purchased	No				Each	658.0000		2		4/5/14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		40							
					104603	40							
				ST301		618							
					116188	318							
					116549	300							
NAS1149C0432R  Washer		Purchased	No				Each	6,610.000		4		4/5/14	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST297		6610							
					116900	1610							
					117291	5000							
D4148-3  Stud Receiver, Lower		Manufactured	No			100	Each	0.0000		1		4/5/14	

B67733 (W)

W/O:		WORK ORDER CHANGES						
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Page 2

Work Order ID: 68117

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 4/7/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

D4148-5 Manufactured No

100

Each

4.0000

1

1



Eyebolt Stud



ES 11/04/14

Location

Loc Qty

Loc Code

ST133

4

66890

4

D4274-3 Manufactured No

100

Each

2.0000

2

2



Plate, Aft Support



ES 11/04/14

Location

Loc Qty

Loc Code

ST139B

2

65886

2

D4276-1 Manufactured No

100

Each

0.0000

1

1



Aft Beam

AN3C12A



Bolts



B65885 (1x)

ES 11/04/14

Purchased No

100

Each

91.0000

6

6



ES 11/04/14

Location

Loc Qty

Loc Code

ST351

91

116924

41

117313

50

MS20615-4M18 Purchased No

100

Each

58.0000

8

8



Rivet



ES 11/04/14
M114808 (8x)

Location

Loc Qty

Loc Code

GA

58

115037

58

Wednesday, April 06, 2011 3:00:01 PM

Shop Packet Print

Page 2

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Page 3

Work Order ID: 68117



Parent Item: D4271-013



Parent Item Name: Aft Beam Assembly

Start Date: 4/7/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-3 Purchased No

100

Each

1,077.000

6

6



Nut

EG 5/11/04/14

Location

Loc Qty

Loc Code

FG 80

103691 80

FP-B 11

112314 11

ST301 986

112314 986

NAS1149C0332R Purchased No

100

Each

5,085.000

12

12



Washer

EG 5/11/04/14

Location

Loc Qty

Loc Code

ST297 5085

115832 34

116304 55

117291 4996

12

Wednesday, April 06, 2011 3:00:01 PM

Shop Packet Print

Page 3

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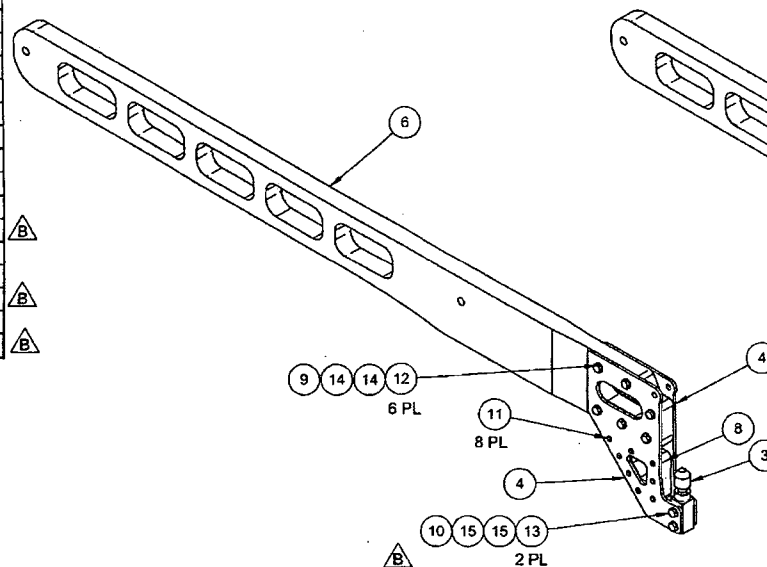
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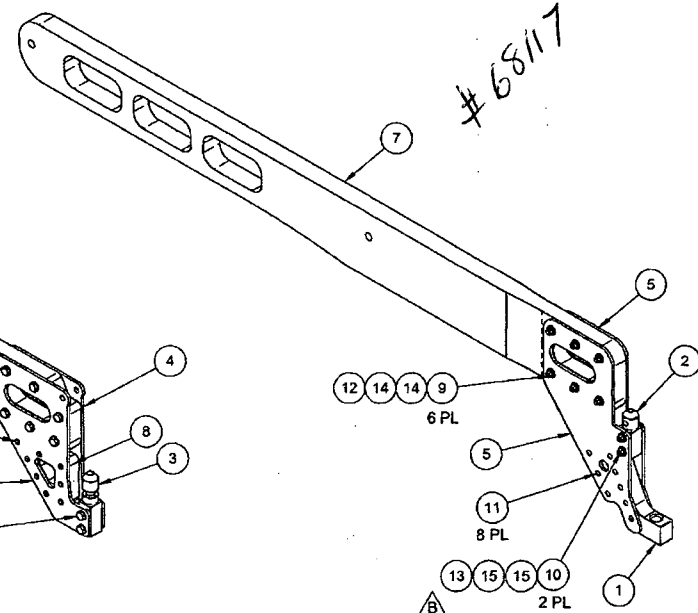
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ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1		1	D4148-3	STUD RECEIVER
2		1	D4148-5	EYEBOLT STUD
3	1		D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7		1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	6	6	AN3C12A	BOLT
10	2	2	AN4C13A	BOLT
11	8	8	MS20615-4M18	RIVET
12	6	6	MS21043-3	NUT
13	2	2	MS21043-4	NUT
14	12	12	NAS1149C0332R	WASHER
15	4	4	NAS1149C0432R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

RELEASED
2010-12-06

B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	SC		
CHECKED	#		
MFG. APPR.	#		
APPROVED	#		
DE APPR.	#		
DATE	10.12.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4271** REV. B
SHEET 1 OF 2
TITLE **SUPPORT BEAM ASSEMBLIES** SCALE NTS

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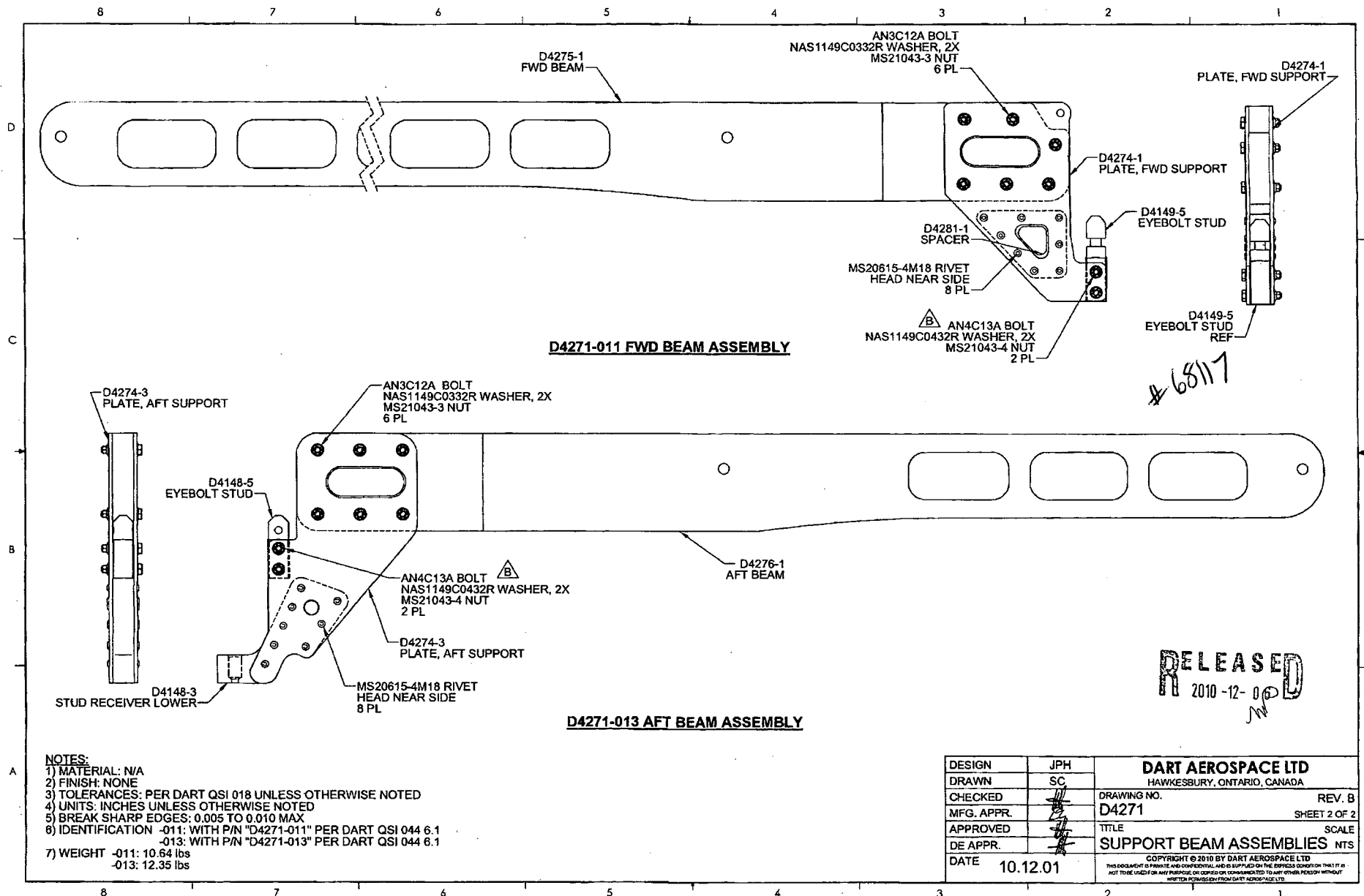
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